

*Sub A3*ABSTRACT OF THE INVENTION

The present invention provides a new and improved process of producing vehicle grille guards by gas-assisted injection molding and the grille guards produced thereby. The process includes injecting a plastic resin into a mold cavity in an amount less than the total volume of the mold cavity. An inert gas is then injected into a center portion of the cavity and a hollow gas channel extending throughout the center portion is formed, forcing the plastic resin to flow along an outer surface of the cavity.